

Date: Wednesday, 12/6/2006 10:39:32 AM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INITIAL PROTOTYPE TEMPLATE
Job Number : 00064A	
Estimate Number : 10068	
P.O. Number :	Part Number : INITIAL PROTOTYPE D3542-1
This Issue : 12/6/2006 S.O. No. :	Drawing Number :
Prsht Rev. : NC	Project Number : AC0002
First Issue : 11/28/2006 Type : PURCHASED PARTS	Drawing Revision :
Previous Run : 00063A	Material :
Written By :	Due Date : 6/21/2006 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Project #:	
	Description:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

M606176 1.0" thick batch: **M14389**

Comments:

- Cut part on waterjet per Dwg D3542 **M 06/12/05**- Bore to finish size per Dwg D3542 **Jun/06-12.05**

- QCS

EE 06.12.06

2.0	PG	PURCHASING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00064A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS24693C272

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

17.0

MS24693C273

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

18.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

ENGINEERING RESOURCE #1

Approval of project manager

EC 07.03.15

19.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

07/03/15

Job Completion



U 07-03-15

LOSS # 00007

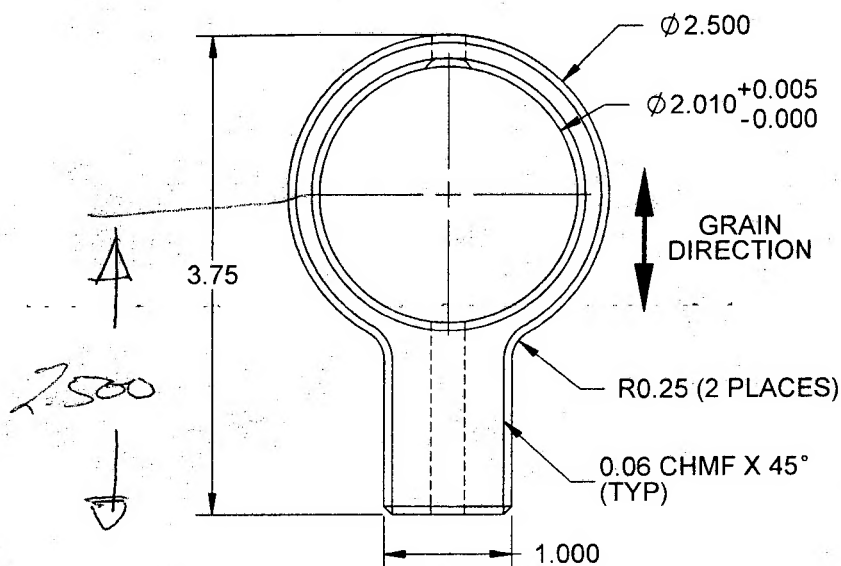
-w/o

PRELIMINARY ISSUE

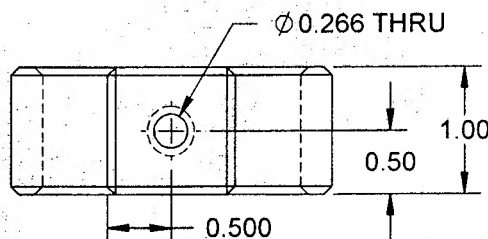
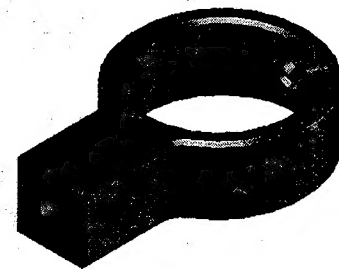
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

UNDER REVIEW

06-11-27 LE



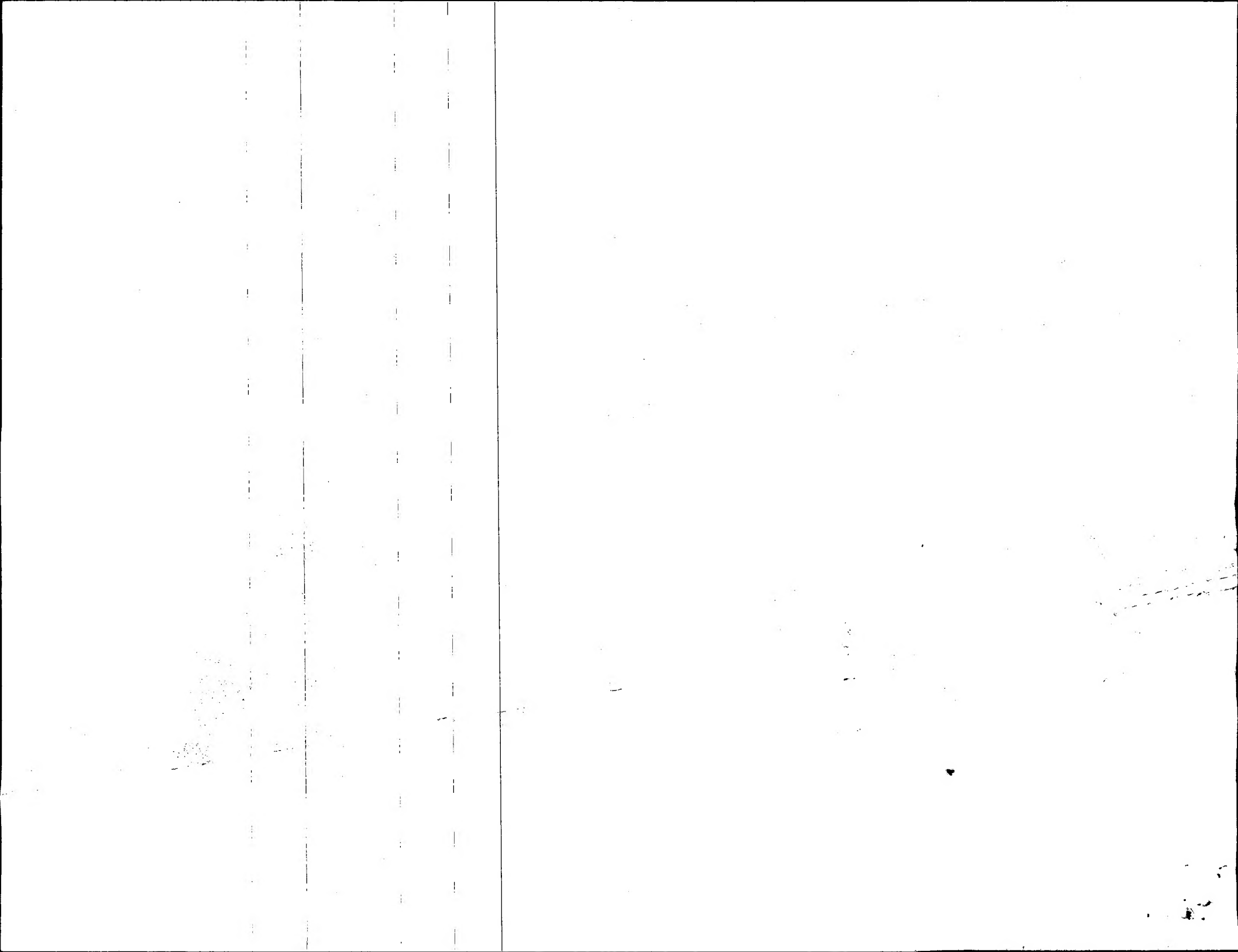
REFERENCE

**D3542-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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COPPER & BRASS SALES
400 RENAISSANCE CENTER
SUITE 1900
DETROIT

MI 48243

COPPER & BRASS SALES, INC C
6700 POE AVENUE

DAYTON

OH 45414

CUSTOMER P.O. NO.

GOVT. CONTRACT NO.

C48524

Products as follows

ASTM B 221-02 ASME SB 221-99
QQ-A-200/8 AMS-QQ-A-200/8

MEETS T6 TEMPER REQUIREMENTS
6061-T6511 ORDER ITEM
ASTM B 221 SUPERIOR QUALITY PLATE

ORDER NUMBER

ALLOY AND TEMPER

582115

6061-T6511

00301902

OH 582115

INVOICE NO.

INVOICE DATE

GROSS WEIGHT

B/L NO.

DATE SHIPPED

3852

149372

VIA

OPEN TOP TRUCK
F.O.B.

DEST N

AUTHORIZED SIGNATURE(S)

TOM G. SMALL

12/11/03

AEP MANAGER, QUALITY ASSURANCE

We hereby certify that the material covered by this report has been inspected and tested accordance with the Seller's standard sampling plan or the requirements of any specification of the material described in this report and has been found to meet the applicat requirements described herein, and that samples representative of the material met t composition limits and had the mechanical properties shown. Also, note that Mercury is not normal contaminant in aluminum alloys. Neither Mercury nor any of its compounds are us in the manufacture of our extrusions.

Alcoa Engineered Products

ITEM	ITEM DESCRIPTION	PRODUCT CODE	QUANTITY SHIPPED		WGT. IN LBS. OR AS INDICATED
			PCS., FT., ETC.		
001	C/P 089551 ACC-U-PLATE 1.000(+.038/- .000)X12(+.168/-0 SEC 510989 LEN 12' 1/2" WFC (W 14.481 F 02 C 12.10)	R04010	22 PC 264.9 FT 3 BNDLS		3834

REFERENCE ONLY

MECHANICAL PROPERTIES
STRENGTH KSI*

LOT NUMBER	RACK FROM/TO	NUMBER OF TESTS	TENSILE				YIELD***		CONDUCTIVITY		ELONG % IN 2" OR 4D	
			MIN.		MAX.		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.
582115-001	A /B	1	46.4	46.4	44.8	44.8					10.3	10.3

CHEMICAL COMPOSITION IN PERCENT MAXIMUM UNLESS SHOWN AS A RANGE

ALLOY SILICON IRON COPPER MANGANESE MAGNESIUM CHROMIUM ZINC TITANIUM
6061 0.40-0.8 0.7 0.15-0.40 0.15 0.8-1.2 0.04-0.35 0.25 0.15

OTH/EACH OTH/TOT ALUMINU
0.05 0.15 REMAINDE

* KIPS PER SQUARE INCH. ONE KIP EQUALS ONE THOUSAND POUNDS.
** WHEN 2 OR MORE TESTS PER RACK ARE MADE, THE HIGHEST AND LOWEST VALUES ARE REPORTED.
*** YIELD STRENGTH IS DETERMINED BY THE 0.2% OFFSET METHOD.

Alcoa Extrusions, Inc.

M14389